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RBE1X56-137-180
Job Sheet 193926



Part No: RBE1X56-137-180

Job Qty: 2 pcs

Part Name: Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X56-137-180 Rev 2 IPP Rev. A 19.04.15 New issue DP Verify DD

Ship Via:

Bill of Materials



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Container No: S193670



Part: RBE1X56-137-180

Job No: 193926

Serial No/Batch: S193670

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/25/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	6/26/19	0.00	0.40		Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	6/26/19	0.00	0.00		QC 5 - 10		DAS JUN 25 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	2 pcs	6/26/19	0.00	0.00		Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	6/26/19	0.00	0.00		QC 21 - FG - 21		DAS JUN 28 2019 70 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op
Descriptions: 100 - Assemble as per DWG.

Job BOM

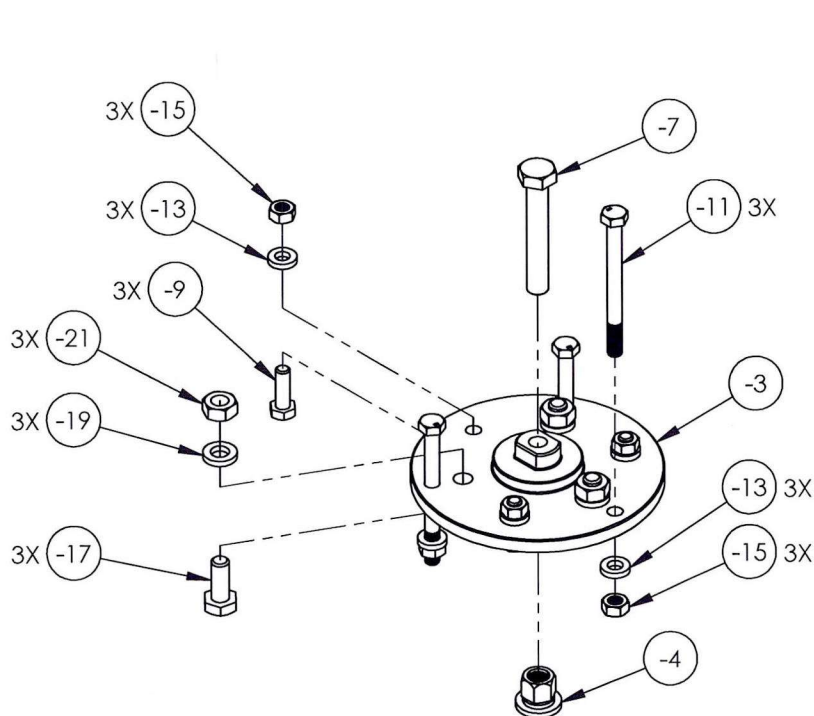
Part / Item	Component Name	Quantity	Operation	Container
90591A161	Hex Nut M8 x 1.25	12 Ea (6 ea)	100-Small Fab - 1	FM138414-7
90854A167	Hex Head Cap Screw, M8 X 1.25mm X 25mm	6 Ea (3 ea)	100-Small Fab - 1	5177922
90854A189	Hex Head Cap Screw, M10 X 1.5mm	6 Ea (3 ea)	100-Small Fab - 1	5177925
91280A560	Hex Head Cap Screw, M8 X 1.25mm X 90mm	6 Ea (3 ea)	100-Small Fab - 1	5177885
92497A450	Hex Nut	6 Ea (3 ea)	100-Small Fab - 1	5091259
98035A105	Flat Washer, M8	12 Ea (6 ea)	100-Small Fab - 1	5177851
98035A106	Flat Washer	6 Ea (3 ea)	100-Small Fab - 1	5177856
RBE1X56-137-180-3	Plate	2 pcs (1 ea)	100-Small Fab - 1	5188211
RBE1X56-137-180-4	Swivel Pad Assembly	2 pcs (1 ea)	100-Small Fab - 1	5192103
RBE1X56-137-180-7	Bolt (Modified B/O)	2 pcs (1 ea)	100-Small Fab - 1	5185055

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A161	12	72	0
	90854A167	6	25	0
	90854A189	6	10	0
	91280A560	6	10	0
	92497A450	6	49	0
	98035A105	12	20	0
	98035A106	6	110	0
	RBE1X56-137-180-3	2	6	0
	RBE1X56-137-180-4	2	4	0
	RBE1X56-137-180-7	2	4	0
Part Specifications				
Specifications could not be found.				

Plex 6/25/19 7:28 AM dart.boucher.sylvie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0126	UPDATED TO NEW STANDARD. ADDED EC635, H135 TO USED ON MODELS. -3 -5 -7 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -3 CH'D DIMS WAS Ø 5.508 IS Ø 5.50, WAS Ø.985 IS Ø.99. DELETED DIMS 3X 120°, 6X 120°, ADDED DIM 60° TYP. -4 ADDED TO BOM. ADDED DRAWING. -5 CH'D DIM WAS Ø.998 IS Ø 1.00, WAS Ø.693 IS Ø.69, WAS Ø.098 IS .10, WAS .125 IS .13, WAS .484 IS .48, WAS Ø.073 IS Ø.07. -7 CH'D DESCRIPTION WAS HEX HEAD CAP SCREW IS BOLT. CH'D B/O REF WAS #91280A010 IS (FASTENAL #0159018). CH'D DIMS WAS 2.925 IS 2.93, WAS Ø.375 DEPTH .125 IS Ø.20 ▽.13, WAS M12 X 1.75 IS (M12 X 1.75 - 6h). -9 CH'D B/O REF WAS #91310A535 IS (#90854A167). -11 CH'D B/O REF WAS #91310A562 IS (#91280A560). -15 CH'D B/O REF WAS #90685A045 IS (#90591A161). -17 CH'D B/O REF WAS #91310A626 IS (#90854A189). -21 CH'D B/O REF WAS #90685A046 IS (#92497A450).	8/29/2016	DEW	JAG



NOTE:
REFERENCE AIRBUS T/N: 1X56137180.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	PLATE	1018/1020 CR		2
	X		-4	1	SWIVEL PAD ASSEMBLY			3
	1		-5		PAD	1018/1020 CR		4
			-7	1	BOLT	STEEL	M12 X 1.75mm X 75mm (FASTENAL #0159018) MODIFIED	5
		B/O	-9	3	HEX HEAD CAP SCREW	STEEL	M8 X 1.25mm x 25mm (MCMaster-CARR #90854A167)	1
		B/O	-11	3	HEX HEAD CAP SCREW	STEEL	M8 X 1.25mm X 90mm (MCMaster-CARR #91280A560)	1
		B/O	-13	6	FLAT WASHER	STEEL	M8 (MCMaster-CARR #98035A105)	1
		B/O	-15	6	HEX NUT	STEEL	M8 X 1.25mm (MCMaster-CARR #90591A161)	1
		B/O	-17	3	HEX HEAD CAP SCREW	STEEL	M10 X 1.5mm (MCMaster-CARR #90854A189)	1
		B/O	-19	3	FLAT WASHER	STEEL	M10 (MCMaster-CARR #98035A106)	1
		B/O	-21	3	HEX NUT	STEEL	M10 X 1.5mm (MCMaster-CARR #92497A450)	1
	1		-23		SWIVEL NUT	STEEL	M12 X 1.75 (CARR LANE #CLM-12-SN) MODIFIED	3
	ASSY -4							

DART AEROSPACE

PULLER

DWG NO. **RBE1X56-137-180**

REV **2**

MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
HEAT TREAT	
FINISH	
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:4
DATE	7/8/2010
SHEET 1 OF 5	